Thursday, 3/8/2007 3:40:49 PM Kim Johnston **Process Sheet** : LOCK PLATE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 31145 **Estimate Number** : 10332 NA Part Number : D2534 P.O. Number S.O. No. : 11/17 : D2534 REV D : 3/8/2007 **Drawing Number** This Issue : N/A : NC, Prsht Rev. Project Number : MA First Issue Type : SMALL /MED FAB **Drawing Revision** : 30398 : NIA Previous Run Material : 3/23/2007 Each Due Date Qty: 40 Um: Written By Checked & Approved By : Est Rev:A New Issue Comment 35 05-11-07 JLM Est Rev:B Now on Waterjet 06-06-20 JLM **Additional Product** Job Number: Description: **Machine Or Operation:** Seq: #: M304S11GA 304/316 .125 Sheet 1.0 Comment: Qty.: 0.0448 sf(s)/Unit Total: 1.7934 sf(s) 304/316 .125 Sheet (M304S11GA) 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2734 Dwg Rev: D ЛM Prog Rev:___iD 07/03/18 2-Deburr if necessary 3.0 QC2 07 03 12 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING 1 5.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQA	\: <u> </u>	<u>∑</u> Date: <u></u>	7/03/14				

QA: N/C Closed: ____ Date: ____

	•	WORK ORDE	R NON-CONFORMANCE (NCR)							
Description of NC			Corrective Action Section B			A 1	Τ			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			
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	STEP	STEP Description of NC Section A	STEP Section A Initial	STEP Section A Initial Action Description	STEP Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Section A Initial Action Description Sign & Verification Approval			

NOTE: Date & initial all entries

E ≩e: User: Thursday, 3/8/2007 3:40:50 PM

Kim Johnston ...

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK PLATE

Job Number: 31145

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 870314

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
					T.						
Port No	• .	DAP#: Foult Cotogony NCE		No DOA		Data					

Part No:	PAR #: Fault Category:	NCR: Yes No	DQA:	Date:
		QA: N/C CI	osed:	Date:
ICR:	WORK ORDER NON-CONFORM	ANCE (NCR)		

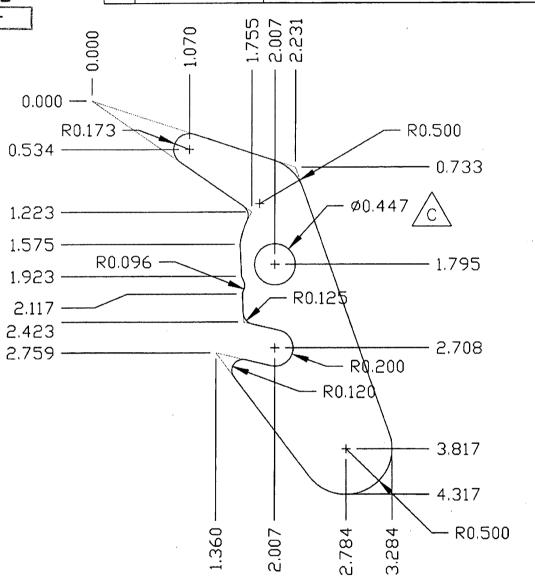
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			Approval	Ammanual	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspecto	
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NOTE: Date & initial all entries



DRAWN BY DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA **B WILLIAMS** CHECKED DRAWING NO. REV. D APPROVED D2534 SHEET 1 OF 1 TITLE SCALE DATE LOCK PLATE 04.12.14 96.07.26 HOLE WAS 0.328 UPDATE NOTES D 04.12.14

RELEASED 04.12.16 -



D2534 LOCK PLATE

SHOP COPY

AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK) RETURN TO (REF. DART SPEC. M304S11GA)

ENGINEERING

2) FINISH: NONE UNCONTROLLED COPY

3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015

SUBJECT TO AMENDMENT

4) ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	31145
	Part Number:	Da534
Description: Lack Plate	1	541
Inspection Dwg: D2534, Rev:D	•	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article 3 Prototy	pe
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Drawing Dimension	Tolerance	Actual Dimension	Accept	lejest	Method of Inspection	Comments
\$0.447	+0.006-0.001	0.447	1		vern	
R0.500	+1-0.010	R0.500	1		RADIUS GU	ngl
RO.173	+1-0.010	RO.173	1		RADIUS GO	
20.096	+1-0.010	RO.096	1		RADIUS GUY	
R0.125	+1-0.010	RO.125	J		RADIUS GU	1 A -
R0.120	+1.0.010	RO. 120	1		RADIUS 6	, A
RD 200	+1-0.010	RO.200	V		RADIUS GUA	se
0.125	71-0.010	0.117	1		vern	0
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Meas	ured by:	m m	Audited by:	Pro	totype Approval:	
	Date:	07 03 12	Date: 07/03/	12	Date:	
Rev	Date	Change			Revised by	Approve
A	Jako	New Issue			KJ/JLM	

